

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005941**Date Inspected:** 26-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components**Summary of Items Observed:**

On the date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 6-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing:

For Green Tag

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. SP 330-001 017,018,019,021 005582 11EE

2. SP 229-001 017,018,019,021 005584 11DE

3. BP 051-001 008,010,012,014 005583 11AW

Bay# 6-Tower Assembly:

This QA Inspector randomly observed the following work in progress:



---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

### SMAW Process:

Welding of weld joint# B/B-2 located on PCMK NSD1-DPSA3-17. Welder is identified as 048617. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

Welding of weld joint# B/B-3 located on PCMK NSD1-DPSA3-17. Welder is identified as 066236. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5

### FCAW Process:

Welding of weld joint# 3,14 located on PCMK WD1-CBSA3-1-8. Welder is identified as 220069. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F-1

Welding of weld joint# 22 located on PCMK WD1-CBSA3-1-8. Welder is identified as 019006. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F-1

Welding of weld joint# 44 located on PCMK WD1-CBSA3-1-8. Welder is identified as 053609. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F-1

Welding of weld joint# 46 located on PCMK WD1-CBSA3-1-8. Welder is identified as 209554. ZPMC QC is identified as Liu Zhi. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P4-F-1

### Bay# 7-OBG Assembly

This QA Inspector randomly observed the following work in progress:

### FCAW Process:

Welding of weld joint# 9&10 located on PCMK BP 080-001. Welder is identified as 053742. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joint# 13&14 located on PCMK BP 080-001. Welder is identified as 051246. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joint# 17&18 located on PCMK BP 080-001. Welder is identified as 202841. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

document

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

---